

Work Order ID 59406

Thursday, June 03, 2010 2:11:29 PM



Page 1

Item ID:	D2739	Accept		Setup	Start	
Revision ID:						
Item Name:	350 I Beam			Stop		
Start Date:	6/3/2010	Start Qty: 7.00				
Required Date:	6/10/2010	Req'd Qty: 7.00				
Reference:						

Approvals:	Process Plan:	<i>MP</i>	Date:	10-6-3	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:		Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev D								
100	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739. 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends. 5-Deburr								
120	Chemical Conversion Coat per QS1005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							

DP 10-6-4
BE 10/06/08
BE 10/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2739

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 I Beam

Start Date: 6/3/2010 Start Qty: 7.00

Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/6/6/09



140

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

x7

JE 10/6/09

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/6/09

MF
10-6-9

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 59406



Parent Item: D2739

Parent Item Name: 350 I Beam

Start Date: 6/3/2010

Required Date: 6/10/2010

Comments: IPP Rev: C ☐ 02.11.28 ☐ Reformat ☐ KJ
IPP Rev: D 06-03-21 As Per Rev C JLM ☐
IPP Rev: E 07-07-28 As per Rev D JLM Verified By:

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D2600-5-108		Manufactured	No			100	Each	189.0000	1	7			



Extrusion 'I Beam' thin



Location

Loc Qty

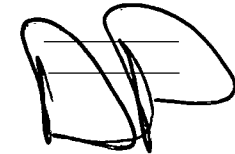
Loc Code

LG

47814

189

189

 10-6-4

W/O:		WORK ORDER CHANGES					
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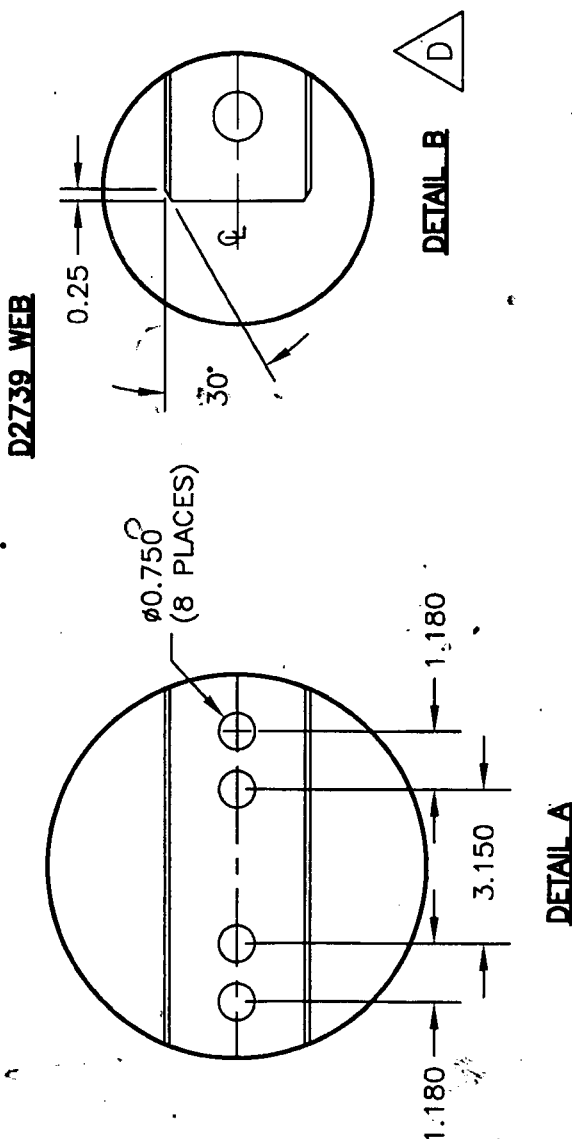
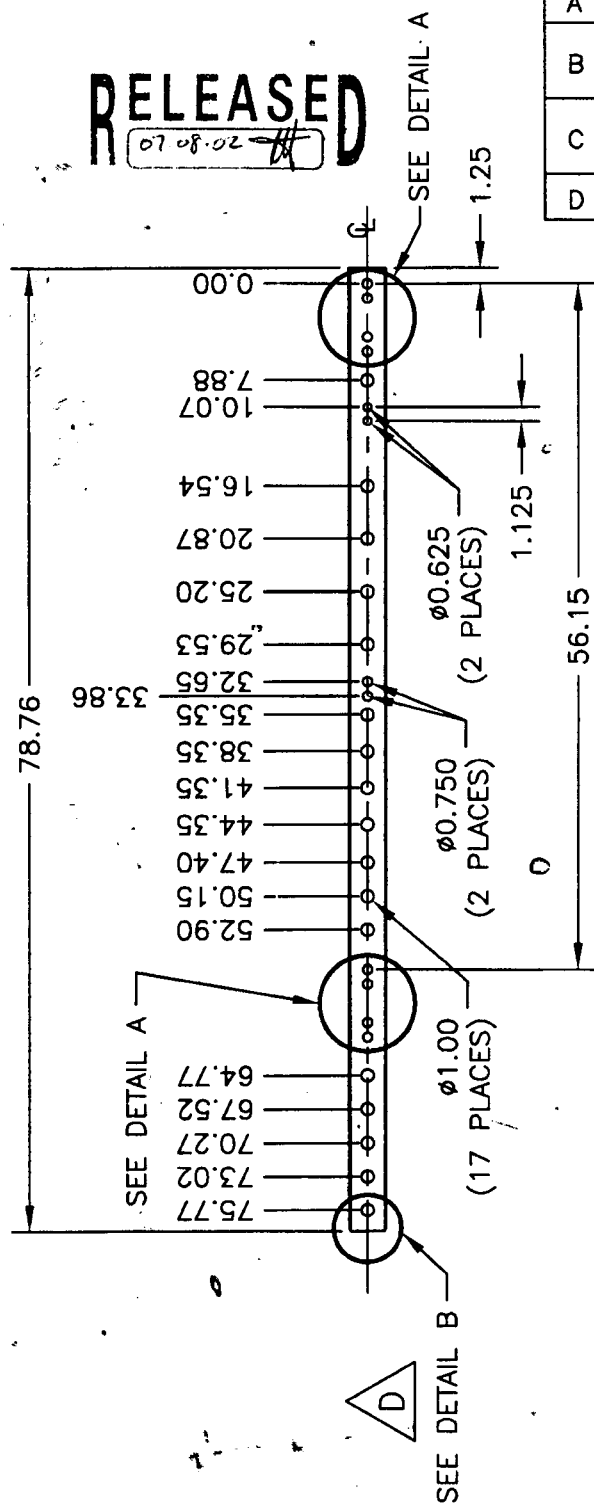
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DESIGN PH		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH		APPROVED HA		DRAWING NO. D2739 REV. D SHEET 1 OF 1	
DATE 07.05.29			TITLE WEB SCALE 1:15		
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B			



NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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